

Work Order ID 146522
Wednesday, May 18, 2016 1:45:30 PM

BHT

146522

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Item ID: D2804-042 Accept *N900040100* Setup Start *NS1*
Revision ID: 630-033--03A Stop *NS2*
Item Name: RH Step Fwd Bracket
Start Date: 5/19/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 5/25/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: dem Date: 16/05/18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2804	Rev C

100		0.00
100	Small Fab	
Small Fab	Memo	0.20
Small Fab	Press D2805-2 into arm as per Dwg D2804	

4X 16/05/18 DAS 36 7.89

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.08
Quality Control		

④ 16-05-19 DAS 9 9-89

125	Spray Painting per QSI005 4.2	0.00
125		
SprayPaint	Memo	0.00
Spray Painting	Prime Tempo Grey 4500-P-23 per QSI005 4.2.1.3.2	

4 DAS 41 9-89 16-6-7

134518

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Item ID: D2804-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: RH Step Fwd Bracket

Start Date: 5/19/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/25/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160									
QC	Memo	0.08							
Quality Control									JUN 08 2016
170	Identify as per dwg & Stock Location: <u>St 475</u>	0.00							
170									
Packaging	Memo	0.04							JUN 08 2016 DAS 6 9-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									10/6/9 <i>[Signature]</i>

MCS

JUN 08 2016

Picklist Print

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Work Order ID: 146522

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Parent Item: D2804-042

D2804-042

Parent Item Name: RH Step Fwd Bracket

Start Date: 5/19/2016

Required Date: 5/25/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	5.0000	1	4			DAS
D2804-2									**			16/05/18	36 9-89
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST475				5					
				127165				3					
				129998				2					
D2805-2		Manufactured	No			100	Each	12.0000	1	4			DAS
D2805-2									**			16/05/18	36 9-89
Stop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				12					
				119687				1					
				125446				3					
				130072				8					
NAS1515H3		Purchased	No			100	Each	291.0000	4	16			DAS
NAS1515H3									**			16/06/08	36 9-89
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				10					
				123301				10					
				GA				38					
				m129521				38					
				ST260				243					
				m131697				243					

Picklist Print

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Parent Item: D2804-042

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Parent Item Name: RH Step Fwd Bracket

Start Date: 5/19/2016

Required Date: 5/25/2016

Start Qty: 4.00

Required Qty: 4.00

AN3C16A	Purchased	No	150	Each	50.0000	2	8		DAS
AN3C16A								**	36
BOLT									9-89

16/06/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST348	50	
m131153	25	
m131957	25	

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D2809	Manufactured	No	150	Each	31.0000	1	4		DAS
D2809								**	36
Washer									9-89

16/06/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	6	
127638	4	
130466	2	
ST011	25	
138750	14	
34035	11	

B146514
4X

MS21043-3	Purchased	No	150	Each	831.0000	2	8		DAS
MS21043-3								**	36
Nut									9-89

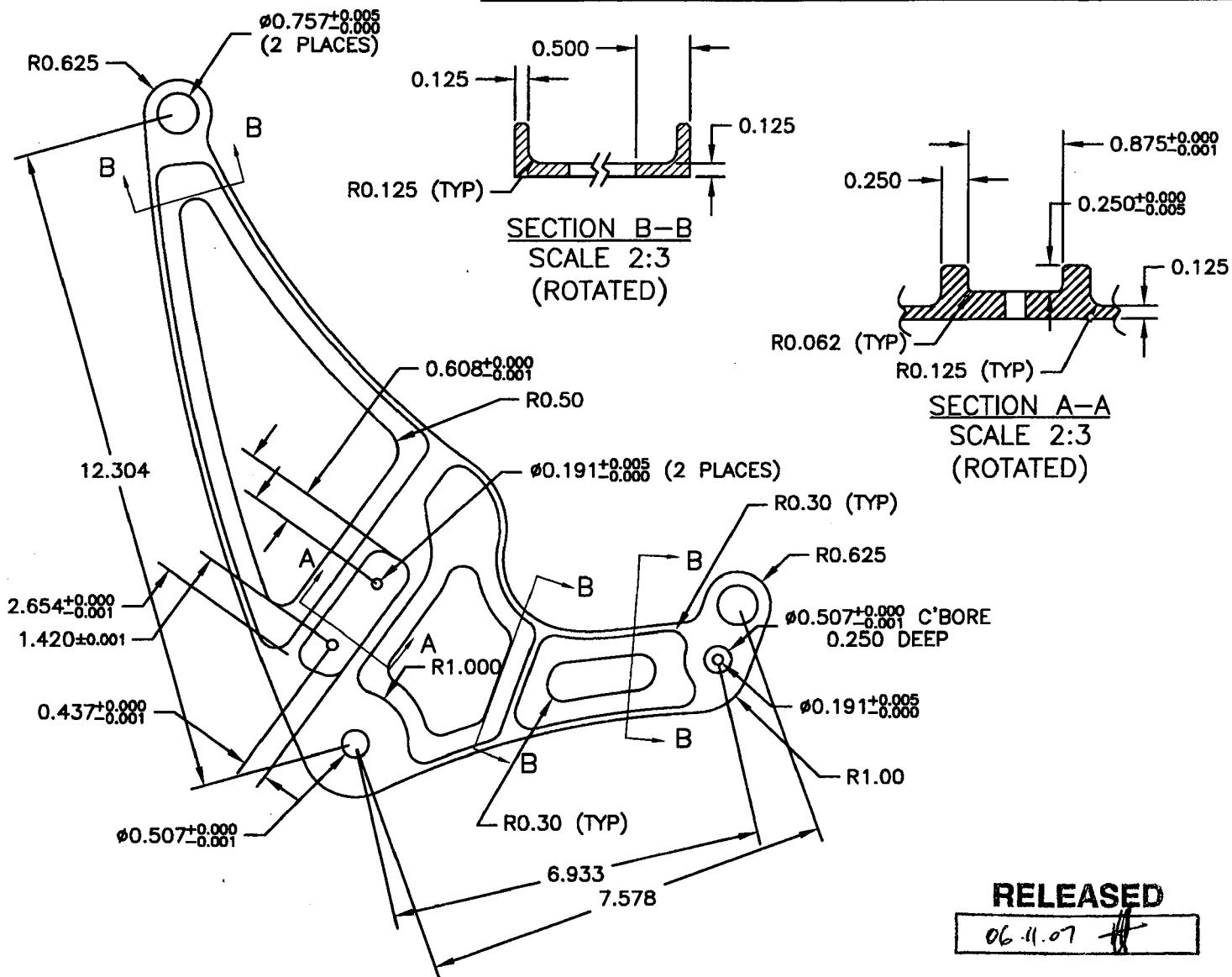
16/06/08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	80	
103691	80	
FP001	11	
m130673	11	
GA	363	
m133990	363	
ST302	271	
m134502	271	
ST304	106	
m131340	106	

8



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



RELEASED

06.11.07 *[Signature]*

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

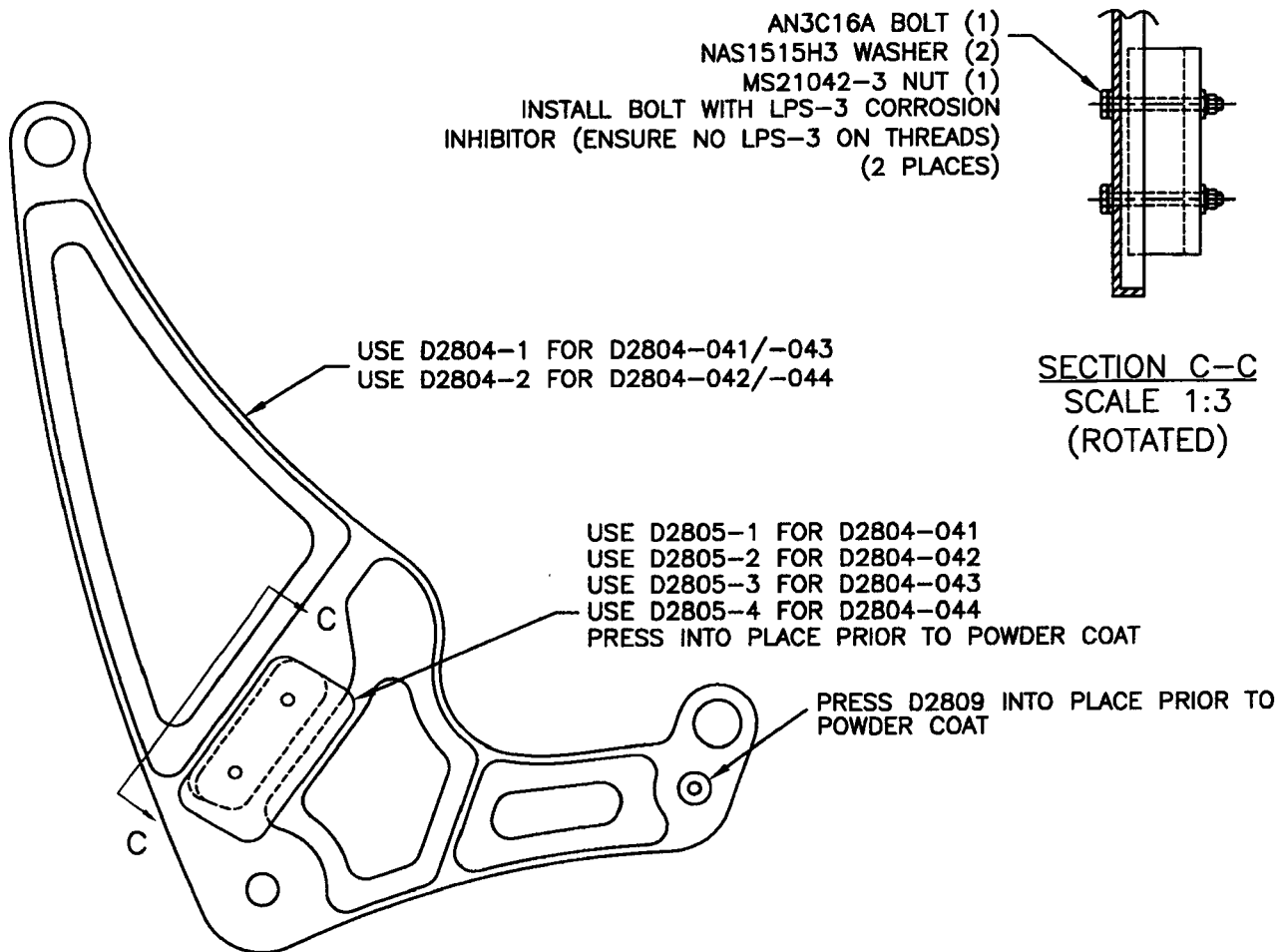
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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